

shp Nov 25 - special print - ERA sp

Work Order ID 76334

76334

Page 1

November-09-11 8:36:46 AM

Item ID: D350-636-017

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Skidtube w/ Training Wearplates, LH

Start Date: 09/11/2011 Start Qty: 1.00

1

Cust Item ID:

Required Date: 14/11/2011 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals: Process Plan: M.C.U

Date: 11/11/09

Tooling:

Date:

Run Start *NR1*

QC:

Date:

SPC (Y/N):

Date:

Stop *NR2*

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D4168

A

IIN-D350-636

I

100

0.00

100

DOCUMENT CONTROL

DC

Memo

0.00

Document Control

Photocopy blue file and type labels per PPP D350-636-017 CHG 002

[Handwritten signature]

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

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Run Start ***NR1***

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Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
110	Skidtubes	0.00							
110									
Skidtubes	Memo	0.00							
Skidtubes	1- Pick D2600-3 Bent								
	2- Deburr FWD and AFT ends, remove bending marks. Scribe batch# inside AFT end per dwg D2750								
	3- Drill pilot holes for blade fitting bolt holes using DT8983. Open to 0.500", deburr.								
	4- Locate DT8330 off of blade fitting bolt holes and drill pilot holes for blade fitting								
	5- Drill fwd step holes using DT9616. Ensure proper positioning.								
	6- Drill pilot holes as per Dwg D2750 sheet 4 (D2750-1 details). Drill using drill Jig DT8150 & DT8863A for first side only DT8863B for second side (detail B)								
	7- Clecko DT8863B on second side of tube and drill pilot holes for detail B. ***SECOND SIDE***								
	8- Open up holes for Detail B to 0.375" (4 holes per side) and blade fitting location holes to 0.500" (total of 4 holes per side) as per dwg D2750. Open up holes for ground handling and detail C to 0.500" (8 holes per side)								
	9- Drill pilot holes for wearplates as per Dwg D2750 using DT8108 open to 0.297"								
	10- Open up holes of Detail A to 0.297" (total of 2 holes per side)								

WIA

11-11-15

Dart Aerospace Ltd

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Run Start ***NR1***

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Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

11-Weld D2744 Cap as per Dwg D2750 and QSI 004. Fill grooves in bend left
from bending as per QSI 004
A/R Aluminum Rod batch: *M118735 BE 11-11-15*

12-Grind welds flush as per Dwg D2750

DP 11-11-16

120

QC10- Inspect visual per QSI004- ground welds

0.00

120

QC

Memo

0.00

Quality Control

130

QC5- Inspect part completeness to step on W/O

0.00

130

QC

Memo

0.00

Quality Control

S u l u l i z

S u l u l i z

Dart Aerospace Ltd

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 Required Date: 14/11/2011 Req'd Qty: 1.00 ***1*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
140 *140* HandFinish Hand Finishing	Chemical Conversion Coat per QSI005 4.1 Memo	0.00 0.00	JW	11-11-17					
150 *150* QC Quality Control	QC3- Inspect Part Finish Memo	0.00 0.00							

11-11-18 (X)

Dart Aerospace Ltd

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Reference:

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Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160	Skidtubes	0.00							
160									
Skidtubes	Memo	0.00							
Skidtubes	1-Open up holes of Detail C and ground handling to 0.625" (total of 8 holes per side) as per dwg D2750.								
	2-Open up holes of Detail B to 0.750" (total of 4 holes per side) as per dwg D2750.								
	3- Open float hole to 0.500" (4 per side)								
	4-Chamfer holes of Detail B, C, ground handling and float holes per dwg D2750 (welding instructions on sheet 8)								
	5-Deburr and blow out all chips from inside of tube								
	6- Prepare tube for welding, remove alodine as required.								
	7-Bond web D2739 in place as per QSI 015 A/R Sikaflex-291 batch: <u>119399</u> exp. date: <u>12/08/13</u>								
	8- Weld spacers D3490-1, D3490-3 and D2743 as per dwg D2750 & QSI004 (welding instructions on sheet 8) A/R Aluminum Rod batch: <u>M118735</u>								
	9- At section AJ-AJ drill out x-bolt spacer to 0.404"								
	10-Grind welds flush as per Dwg D2750								

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Cust Item ID:

Required Date: 14/11/2011 Req'd Qty: 1.00 ***1***

Customer:

Reference:

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Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

11-Spot face ground handling holes section (total of 4 places per side) as per dwg D2750 *11-11-19*

12- C'bore section CJ-CJ

13- Deburr holes

***** FOR DELUXE SKIDTUBE IF APPLICABLE DRILL TOW RING HOLE IN TUBE *****

170 QC10- Inspect visual per QSI004- ground welds 0.00

170

QC

Memo 0.00

Quality Control

180 QC5- Inspect part completeness to step on W/O 0.00

180

QC

Memo 0.00

Quality Control

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N900040100

Setup Start *NS1*

Stop *NS2*

Cust Item ID:

Customer:

Reference:

Run Start *NR1*

Stop *NR2*

**Insp.
Stamp**

0.00

190

Memo

0.00

HandFinish

Hand Finishing

Re-alodine tube as per OSI 005 section 4.1.2.1 do not acid etch.

200

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00

200

Memo

0.00

Powdercoat

Powder Coating

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

210

QC3- Inspect Part Finish

0,00

210

Memo

0.00

QC

Quality Control

Inspect for foreign object per QSI 024

see 24 ~~24~~ - work inside of tube
"AAI Scheme" m " " 23 ①

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	ERA
Primer	Sherwin Williams CM0483928
Paint	Polyurethane with Anti Mar Teflon additive CM0143603GA
Clear coat	CM0571080GA

AAI
~~Anodize~~
Alodine
PR-148 adhesion promoter (for anodize)
50/50 mix - Super Koropon and EC2216
Imron 555X

11.11.23

Primer
Paint

	Apical
primer	IAW MIL-P-23377J, TYPE 1 CLASS N &
paint	Epoxy paint Cardinal 7125-E10192

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Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
220		0.00							
220	HandFinishing								
HandFinish	Memo	0.00							
Hand Finishing	1- Install inserts as per Dwg D2750								
230		0.00							
230	HandFinishing								
HandFinish	Memo	0.00							
Hand Finishing	1-Inspect for Foreign Objects								
	2-Spray inside of tube with "LPS-3" batch: <u>N17</u>								
	3-Install blade fitting D3488-041, wearshoes and ground handling hardware as per dwg D2750								
	SIKA FLEX 241								
	BATCH: <u>119413</u>								
	EXP DATE: <u>12/01</u>								
	4-assemble o-ring to plug as per dwg D3492 and apply o-ring lube								
	A/R 55-o-ring lube batch: <u>1110346</u>								
	5-Coat all exposed fasteners with "LPS Procyon" batch: <u>11114596</u>								

Dart Aerospace Ltd

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Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
240	QC5- Inspect part completeness to step on W/O	0.00							
240									
QC	Memo	0.00							
Quality Control									
250	Pick Kit	0.00							
250									
Packaging	Memo	0.00							
Packaging									
260	QC4- 100% Inspect kits for completeness	0.00							
260									
QC	Memo	0.00							
Quality Control	*****ensure antiseize is on AN8C21A bolts*****								

Dart Aerospace Ltd

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Run Start ***NR1***

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Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
270		0.00							
270	Packaging								
Packaging	Memo	0.00							
Packaging	Identify and pack for shipping as per PPPD350-636-017								
	Location: _____								
	PPP rev: _____								
280		0.00							
280	QC21- Final Inspection - Work Order Release								
QC	Memo	0.00							
Quality Control									

PP76336

11/11/25

CK 11/11/25

MK
11-11-25

Dart Aerospace Ltd

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Picklist Print

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Parent Item: D350-636-017

D350-636-017

Parent Item Name: Skidtube w/ Training Wearplates, LH

Start Date: 09/11/2011

Required Date: 14/11/2011

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP rev:A 10.09.28 new issue DD verf:EC
11.04.14 ecn11-553 DD verf:EC
per NCR 11-906 DD verf:EC

IPP Rev:B
IPP Rev:C 11.10.18 as

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

D3490-1 Manufactured No

160

Each

74.0000

4

4

D3490-1

Cross Bolt Spacer

**

Location

Loc Qty

Loc Code

LG

8

67773

5

71841

3

LG001

66

62450

2

74875

64

AN3C34A

Purchased

No

230

Each

63.0000

1

1

AN3C34A

BOLT

**

Location

Loc Qty

Loc Code

ST353

63

116075

40

117514

20

118838

3

BE 11-11-19
876233 x4

11/11/25

Dart Aerospace Ltd

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Parent Item Name: Skiddtube w/ Training Wearplates, LH

Start Date: 09/11/2011

Required Date: 14/11/2011

Start Qty: 1.00

Required Qty: 1.00

AN3C36A

Purchased

No

230

Each

204.0000

4

4

AN3C36A

BOLT

**

11/11/25

Location

Loc Qty

Loc Code

FG

14

101261

4

116590

10

ST303

24

118757

24

ST353

166

116590

0

119083

2

119125

4

119324

100

119530

60

11/11/25

AN3C37A

Purchased

No

230

Each

182.0000

1

1

AN3C37A

BOLT

**

11/11/25

Location

Loc Qty

Loc Code

ST354

182

116874

11

117010

2

118518

44

118709

50

119324

25

119531

50

11/11/25

Dart Aerospace Ltd

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Start Date: 09/11/2011

Required Date: 14/11/2011

Start Qty: 1.00

Required Qty: 1.00

AN3C42A

Purchased

No

230

Each

38.0000

1

1

AN3C42A

BOLT

**

11/11/25

Location

Loc Qty

Loc Code

ST354

38

106176

1

117763

17

118131

20

D3490-5

Manufactured

No

230

Each

36.0000

4

4

D3490-5

Cross Bolt Spacer

**

BE 11-11-19

Location

Loc Qty

Loc Code

LG001

36

59230

36

D3492-1

Manufactured

No

230

Each

70.0000

8

8

D3492-1

Plug

**

11/11/25

Location

Loc Qty

Loc Code

FP

70

69531

8

74444

62

D3492-5

Manufactured

No

230

Each

24.0000

8

8

D3492-5

Plug

**

11/11/25

Location

Loc Qty

Loc Code

FP

24

70698

24

11/11/25

Dart Aerospace Ltd

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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Work Order ID: 76334

76334

Parent Item: D350-636-017

D350-636-017

Parent Item Name: Skidtube w/ Training Wearplates, LH

Start Date: 09/11/2011

Required Date: 14/11/2011

Start Qty: 1.00

Required Qty: 1.00

D3873-1 Manufactured No

230

Each

1,031.000

7

7

D3873-1

Bushing

**

11/11/25

Location

Loc Qty

Loc Code

ST088

1031

64760

1

68247

4

73829

19

73830

207

73832

400

75481

400

17

D4154-041

Manufactured No

230

Each

1.0000

1

1

D4154-041

Wearplate Assembly

**

1374074 (x1) 11/11/25

Location

Loc Qty

Loc Code

FP

1

71442

1

D4170-1

Manufactured No

230

Each

36.0000

4

4

D4170-1

Bushing

**

11-11-19

Location

Loc Qty

Loc Code

LG

32

68225

1

71844

31

LG002

4

65912

4

4

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Work Order ID: 76334

76334

Parent Item: D350-636-017

D350-636-017

Parent Item Name: Skidtube w/ Training Wearplates, LH

Start Date: 09/11/2011

Required Date: 14/11/2011

Start Qty: 1.00

Required Qty: 1.00

D4171-1 Manufactured No

230 Each 7.0000 1 1

D4171-1

Bushing

**

M 11/11/25

Location

Loc Qty

Loc Code

ST135

7

69037

7

MS21043-3 Purchased No

230 Each 727.0000 5

MS21043-3

Nut

**

X1

84

M 11/11/25

Location

Loc Qty

Loc Code

FG

72

103691

72

ST301

655

118077

1

118614

477

118686

177

NAS1149C0363R Purchased No

230 Each 3,899.000 9

NAS1149C0363R

Washer

**

XJ

97

M 11/11/25

Location

Loc Qty

Loc Code

ST297

3899

114742

3899

X7

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Work Order ID: 76334

76334

Parent Item: D350-636-017

D350-636-017

Parent Item Name: Skidtube w/ Training Wearplates, LH

Start Date: 09/11/2011

Required Date: 14/11/2011

Start Qty: 1.00

Required Qty: 1.00

NAS1515H3L

Purchased

No

230

Each

171.0000

4

4

***NAS1515H3I ***

WASHER

**

11/11/25

Location

Loc Qty

Loc Code

FG

40

102472

40

ST277

131

113362

27

118686

4

119438

100

NAS1611-005

Purchased

No

230

Each

236.0000

8

8

NAS1611-005

O-RING

**

11/11/25

Location

Loc Qty

Loc Code

FP002

136

106099

31

114220

105

FP-A

100

119438

100

NAS1611-010

Purchased

No

230

Each

217.0000

8

8

NAS1611-010

O-RING

**

11/11/25

Location

Loc Qty

Loc Code

FP

196

117460

8

118077

1

118612

3

119438

184

FP-A

21

110915

14

119307

7

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Shop Packet Print

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Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Work Order ID: 76334

76334

Parent Item: D350-636-017

D350-636-017

Parent Item Name: Skidtube w/ Training Wearplates, LH

Start Date: 09/11/2011

Required Date: 14/11/2011

Start Qty: 1.00

Required Qty: 1.00

NAS1149D0863J

Purchased

No

250

Each

214.0000

2

2

NAS1149D0863J

WASHER

**

11/11/25

Location

Loc Qty

Loc Code

ST298

214

118078

114

119307

100

XZ

D2744

Manufactured

No

110

Each

55.0000

1

1

D2744

Cap

**

BE11-11-15

Location

Loc Qty

Loc Code

LG002

13

62715

1

70881

12

WA

42

71861

42

1

D2600-3-BENT

Manufactured

No

110

Each

32.0000

1

1

D2600-3-BENT

Extrusion Bent

**

DP 11-11-15

Location

Loc Qty

Loc Code

LG

32

66875

8

73253

1

75021

9

75022

10

75023

4

①

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Work Order ID: 76334

76334

Parent Item: D350-636-017

D350-636-017

Parent Item Name: Skidtube w/ Training Wearplates, LH

Start Date: 09/11/2011

Required Date: 14/11/2011

Start Qty: 1.00

Required Qty: 1.00

D2743 Manufactured No 160 Each 135.0000 8 8

D2743

Crossbolt Spacer

**

BE 11-11-19

Location	Loc Qty	Loc Code
LG	77	
71839	13	
73403	64	
LG001	58	
67766	4	
68251	54	

D2739 Manufactured No 160 Each 5.0000 1 1

D2739

350 I Beam

**

76140

(P)

11/11/18

Location	Loc Qty	Loc Code
LG	5	
72155	1	
72157	2	
75037	2	

ALS4-1032-225 Purchased No 230 Each 2,302.000 4 4

AI S4-1032-225

Insert

**

4

11/11/25

Location	Loc Qty	Loc Code
ST281	2302	
108696	422	
110768	62	
118386	858	
118966	960	

4

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Work Order ID: 76334

76334

Parent Item: D350-636-017

D350-636-017

Parent Item Name: Skidtube w/ Training Wearplates, LH

Start Date: 09/11/2011

Required Date: 14/11/2011

Start Qty: 1.00

Required Qty: 1.00

AN8C35A

Purchased

No

230

Each

103.0000

1

1

AN8C35A

BOLT

**

11/11/25

Location

Loc Qty

Loc Code

FP

67

117511

1

118286

66

FP-A

1

115960

1

ST345

34

117834

34

ST346

1

114442

0

115188

0

115960

1

D3488-041

Manufactured

No

230

Each

13.0000

1

1

D3488-041

Blade Fitting Assembly, LH

**

11/11/25

Location

Loc Qty

Loc Code

FP

4

69903

4

FP007

1

61689

1

FP008

8

67788

1

71887

7

1375056

11

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Work Order ID: 76334

76334

Parent Item: D350-636-017

D350-636-017

Parent Item Name: Skidtube w/ Training Wearplates, LH

Start Date: 09/11/2011

Required Date: 14/11/2011

Start Qty: 1.00

Required Qty: 1.00

AN6C44A

Purchased

No

230

Each

123.0000

4

4

AN6C44A

BOLT

**

11/11/25

Location

Loc Qty

Loc Code

FG

2

103964

2

ST343

121

118387

1

118985

40

119125

30

119530

50

x4

MS21083C8

Purchased

No

230

Each

87.0000

1

1

MS21083C8

NUT

**

11/11/25

Location

Loc Qty

Loc Code

FP-B

1

115884

1

ST293

1

118077

1

ST303

85

115884

0

118614

41

119309

19

119436

25

x1

D3631-1

Manufactured

No

230

Each

527.0000

8

8

D3631-1

Washer

**

11/11/25

Location

Loc Qty

Loc Code

ST072

527

68062

27

75548

500

x8

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Work Order ID: 76334

76334

Parent Item: D350-636-017

D350-636-017

Parent Item Name: Skidtube w/ Training Wearplates, LH

Start Date: 09/11/2011

Required Date: 14/11/2011

Start Qty: 1.00

Required Qty: 1.00

AN960C10L

NAS1149C0832R

Purchased

No

230

Each

0.0000

4

4

AN960C10L

washer

D2745

Manufactured

No

230

Each

165.0000

8

8

D2745

Bushing

**

1119736(x4) 11/11/25

**

11/11/25

Location

Loc Qty

Loc Code

FP-A

81

69529

1

74446

80

ST021

84

71835

84

x8

NAS1149C0832R

Purchased

No

230

Each

335.0000

1

1

NAS1149C0832R

WASHER

**

11/11/25

Location

Loc Qty

Loc Code

FP-B

7

114915

7

x1

ST297

328

114915

328

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Work Order ID: 76334

Parent Item: D350-636-017

Parent Item Name: Skidtube w/ Training Wearplates, LH

76334

D350-636-017

Start Date: 09/11/2011

Required Date: 14/11/2011

Start Qty: 1.00

Required Qty: 1.00

AN3C6A

Purchased

No

230

Each

268.0000

4

4

AN3C6A

BOLT

**

11/11/25

Location

Loc Qty

Loc Code

FP-A

1

111982

1

ST350

100

119449

100

ST351

167

111982

2

116419

23

116549

2

116704

12

117619

10

117688

1

117872

5

118422

112

x4

MS21043-6

Purchased

No

230

Each

465.0000

4

4

MS21043-6

NUT

**

11/11/25

Location

Loc Qty

Loc Code

FG

20

103693

20

ST300

445

112314

235

117887

10

118384

200

x4

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Work Order ID: 76334

76334

Parent Item: D350-636-017

D350-636-017

Parent Item Name: Skidtube w/ Training Wearplates, LH

Start Date: 09/11/2011

Required Date: 14/11/2011

Start Qty: 1.00

Required Qty: 1.00

D3493-1 Manufactured No

250 Each 39.0000 2

D3493-1

Washer

**

Location

Loc Qty

Loc Code

ST062

39

70697

4

71846

35

MS21083C8

Purchased No

250 Each 87.0000 2

MS21083C8

NUT

**

Location

Loc Qty

Loc Code

FP-B

1

115884

1

ST293

1

118077

1

ST303

85

115884

0

118614

41

119309

19

119436

25

AN8C21A

Purchased No

250 Each 79.0000 2

AN8C21A

BOLT

**

Location

Loc Qty

Loc Code

ST343

79

118045

11

118758

38

119530

30

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Work Order ID: 76334

76334

Parent Item: D350-636-017

D350-636-017

Parent Item Name: Skidtube w/ Training Wearplates, LH

Start Date: 09/11/2011

Required Date: 14/11/2011

Start Qty: 1.00

Required Qty: 1.00

D2741

Manufactured No

250

Each

10.0000

1

1

D2741

Blade, 350 Skidtube

**

Location

Loc Qty

Loc Code

ST466

10

70667

10

1 11/11/22

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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QTY -041	QTY -042	QTY -043	QTY -044	PART NUMBER	DESCRIPTION
X				D4168-041	350 SKIDTUBE ASSEMBLY, LH
	X			D4168-042	350 SKIDTUBE ASSEMBLY, RH
		X		D4168-043	350 SKIDTUBE ASSEMBLY, LH
			X	D4168-044	350 SKIDTUBE ASSEMBLY, RH
1	1	1	1	D2739	WEB
8	8	8	8	D2743	SPACER
1	1	1	1	D2744	CAP
8	8	8	8	D2745	BUSHING
1		1		D3488-041	BLADE FITTING, LH
	1		1	D3488-042	BLADE FITTING, RH
4	4	4	4	D3490-1	SPACER
4	4			D3490-3	SPACER
		4	4	D3490-5	SPACER
8	8	8	8	D3492-041	PLUG ASSEMBLY
8	8			D3492-043	PLUG ASSEMBLY
		8	8	D3492-045	PLUG ASSEMBLY
8	8	8	8	D3631-1	WASHER
7	7	7	7	D3873-1	BUSHING
1	1	1	1	D4154-041	WEARPLATE ASSEMBLY
1				D4168-1	SKIDTUBE WELDMENT, LH
	1			D4168-2	SKIDTUBE WELDMENT, RH
		1		D4168-3	SKIDTUBE WELDMENT, LH
			1	D4168-4	SKIDTUBE WELDMENT, RH
4	4	4	4	D4170-1	SPACER
1	1	1	1	D4171-1	BUSHING
4	4	4	4	ALS4-1032-225	INSERT
4	4	4	4	AN3C6A	BOLT
1	1	1	1	AN3C34A	BOLT
4	4	4	4	AN3C36A	BOLT
4	4	4	4	AN6C44A	BOLT
1	1	1	1	AN8C35A	BOLT
9	9	9	9	AN960C10	WASHER (OR NAS1149CO363R)
4	4	4	4	AN960C10L	WASHER (OR NAS1149CO332R)
1	1	1	1	AN960C816L	WASHER (OR NAS1149CO832R)
5	5	5	5	MS21043-3	NUT
4	4	4	4	MS21043-6	NUT
1	1	1	1	MS21083C8	NUT
4	4	4	4	NAS1515H3L	WASHER

GENERAL NOTES:

- MATERIAL: MAKE D4168-1/-2/-3/-4 FROM D2600-3 EXTRUSION (INITIAL LENGTH = 120.0).
- FINISH:
CHEMICAL CONVERSION COAT PER DART QSI 005 4.1 PRIOR TO INSTALLING D2739 WEB.
POWDER COAT WHITE (REF. 4.3.5.1) PER DART QSI 005 4.3
BLACK ANTI-SKID PAINT AS INDICATED TO 1.0 ABOVE SKIDTUBE CENTER-LINE PER DART 005 4.4 (OPTIONAL).
- TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- UNITS: INCHES UNLESS OTHERWISE NOTED
- BREAK SHARP EDGES: N/A
- IDENTIFICATION: N/A
- WEIGHT: D4168-041/-042/-043/-044 = 32.3 LBS
- WELD PER DART QSI 004
- FINAL CONFIGURATION SHOULD HAVE THE FOLLOWING MINIMUM MECHANICAL PROPERTIES:
MINIMUM YIELD TENSILE STRENGTH = 35 KSI
MINIMUM ULTIMATE TENSILE STRENGTH = 38 KSI
- COAT ALL EXPOSED FASTENERS WITH LPS LABORATORIES "LPS PROCYON" AFTER FINAL ASSEMBLY, CLEAN EXCESS OFF
POWDER COATING WITH MEK DEGREASER.
- SPACER AND PLUG INSTALLED SAME AS SECTION AJ-AJ EXCEPT HORIZONTAL
- SPACER AND PLUG INSTALLED SAME AS SECTION AP-AP EXCEPT HORIZONTAL

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER

NO. 76334 M.C.J
11/11/09

RELEASED
2010-09-15

A	NEW ISSUE	DESCRIPTION	SC	10.08.09
REV.			BY	DATE
DESIGN	SC	DART AEROSPACE USA, INC.		
DRAWN	SC	PORT HADLOCK, WA		
CHECKED		DRAWING NO.	REV. A	
MFG. APPR.		D4168	SHEET 1 OF 11	
APPROVED		TITLE	SCALE	
DE APPR.		350 SKIDTUBE ASSEMBLY	NTS	
DATE	10.08.09	COPYRIGHT © 2010 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR REPRODUCED IN ANY FORM OR BY ANY MEANS WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.		

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

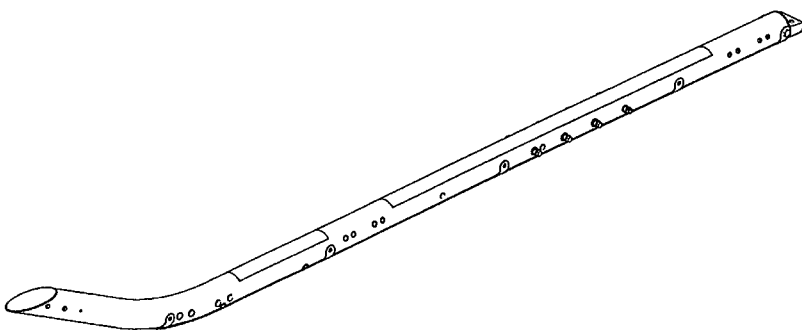
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NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

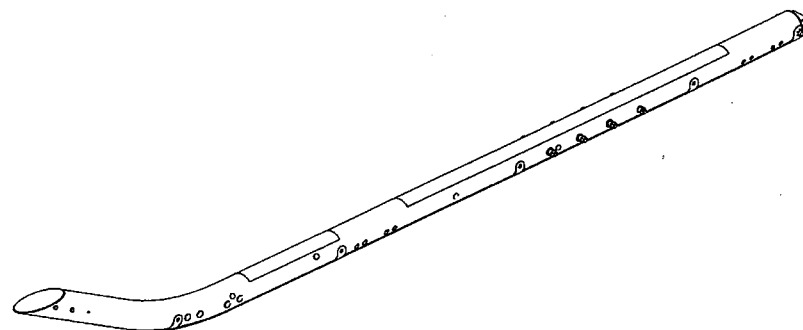
NOTE: Date & initial all entries

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76334



D4168-041 350 SKIDTUBE ASSEMBLY, LH



D4168-042 350 SKIDTUBE ASSEMBLY, RH

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JW

DESIGN	SC	DART AEROSPACE USA, INC.	
DRAWN	SC	PORT HADLOCK, WA	
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. A
MFG. APPR.	<i>[Signature]</i>	D4168	SHEET 2 OF 11
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	350 SKIDTUBE ASSEMBLY	NTS
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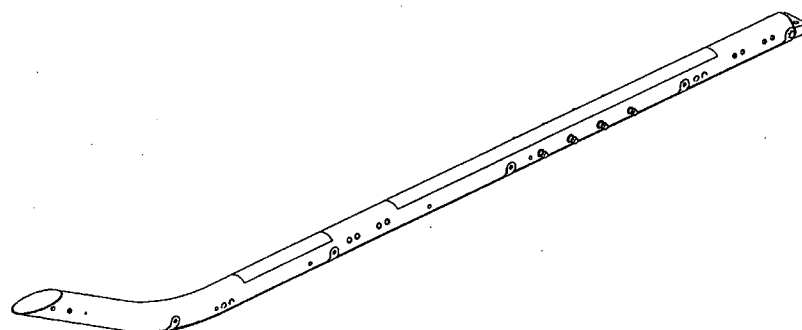
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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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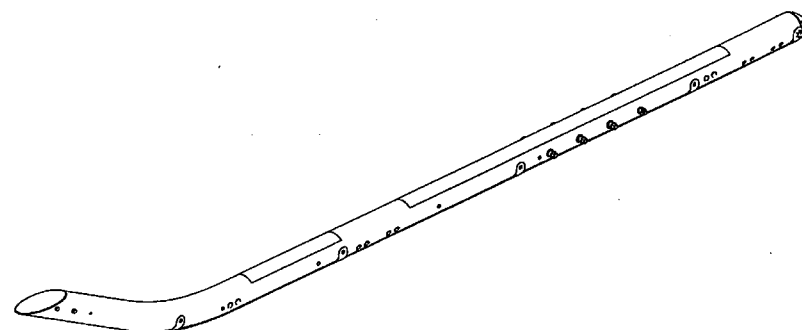
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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D4168-043 350 SKIDTUBE ASSEMBLY, LH



D4168-044 350 SKIDTUBE ASSEMBLY, RH

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W/O:		WORK ORDER CHANGES					
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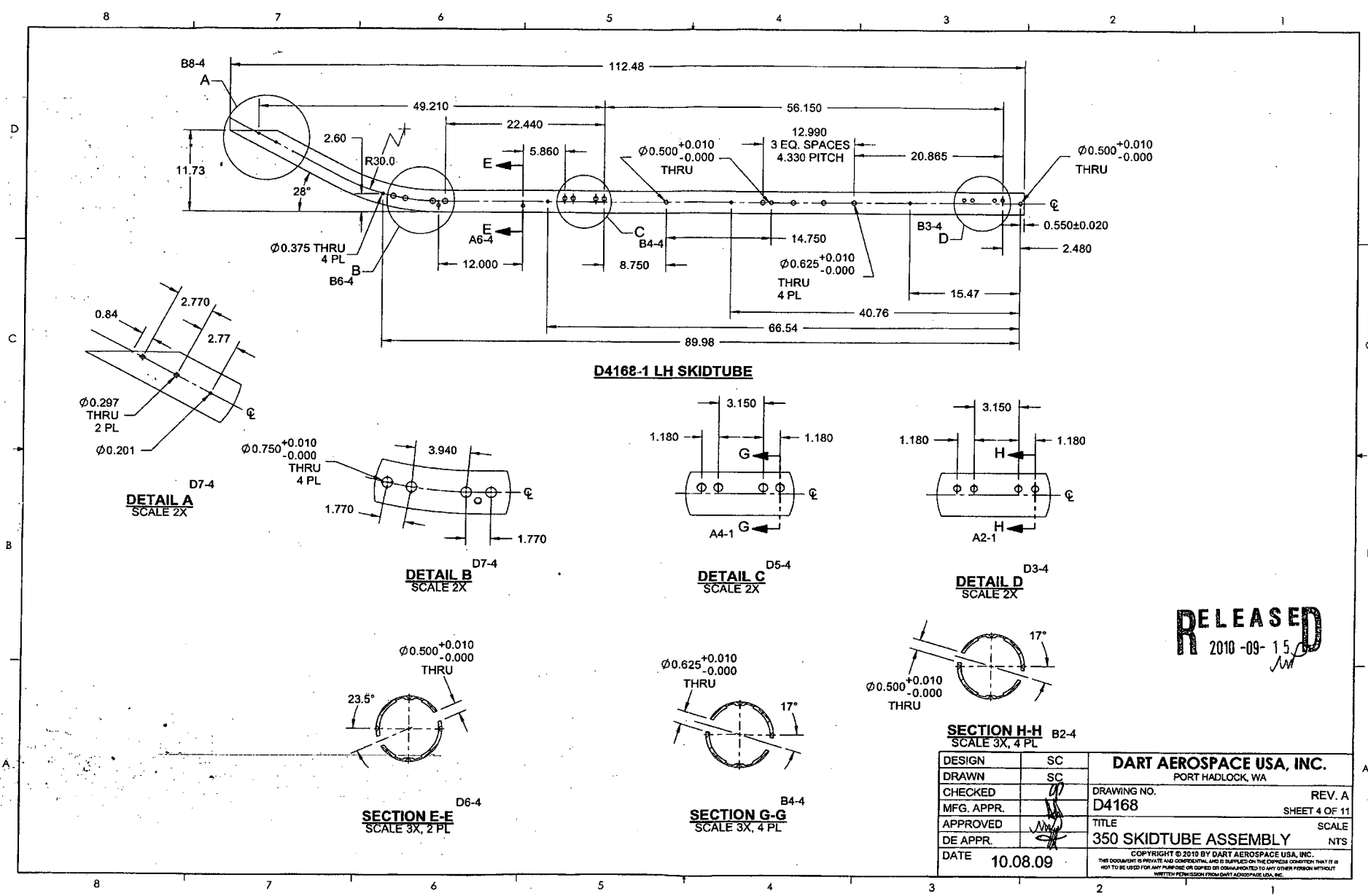
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____





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SECTION H-H		DART AEROSPACE USA, INC. PORT HADLOCK, WA	
B2-4			
SCALE 3X, 4 PL			
DESIGN	SC		
DRAWN	SC		
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE 10.08.09		DRAWING NO. D4168	REV. A
		TITLE 350 SKIDTUBE ASSEMBLY	SHEET 4 OF 11
			SCALE NTS
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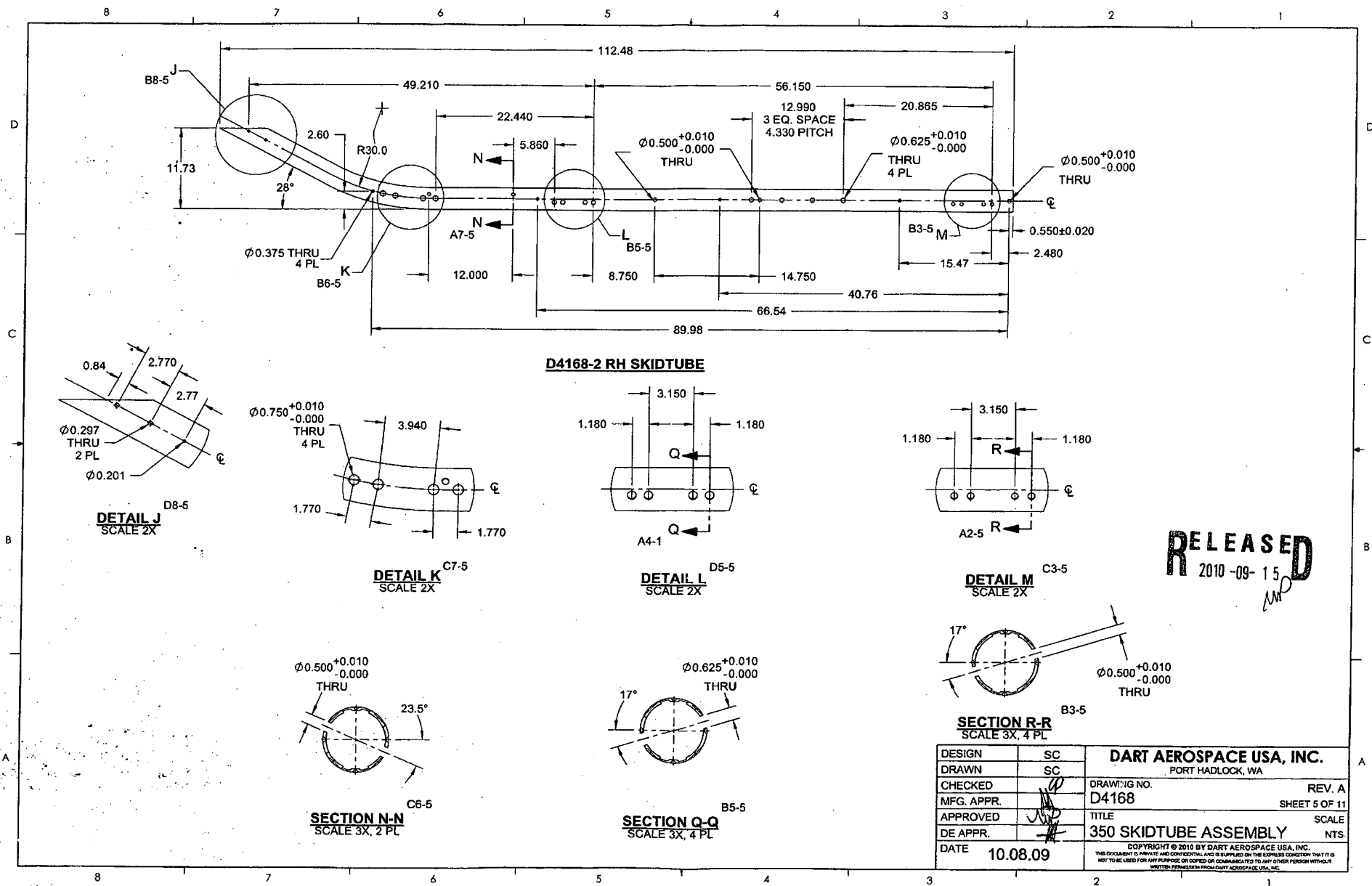
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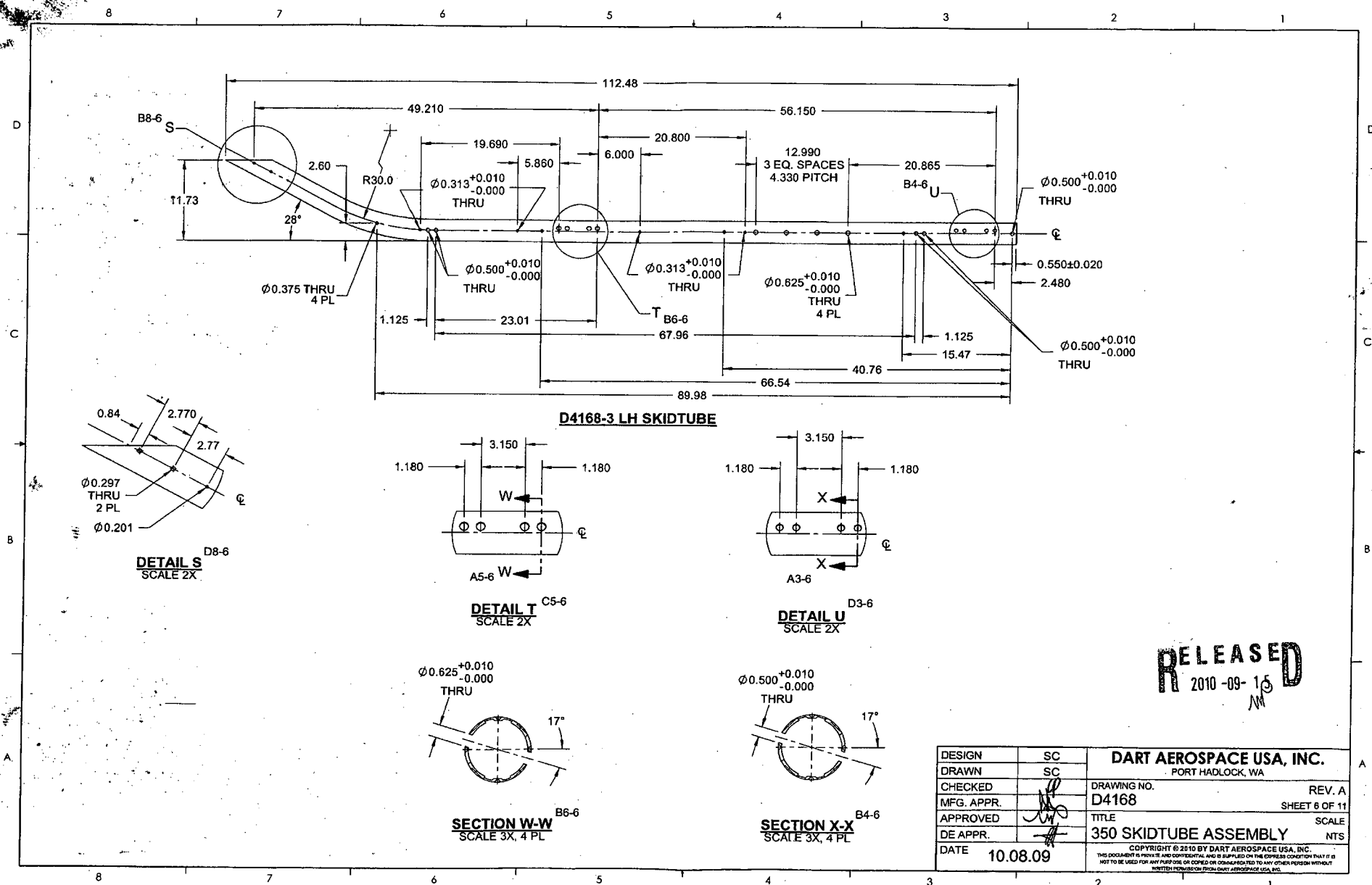
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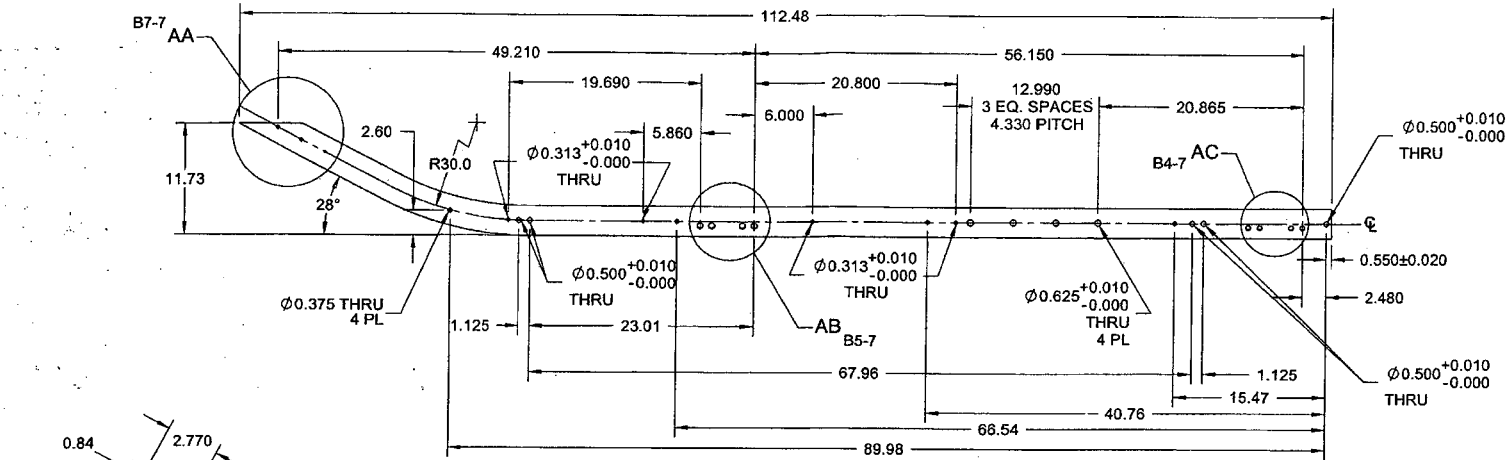
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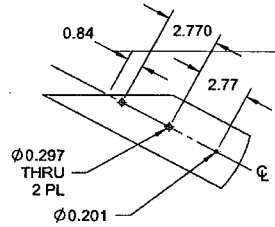
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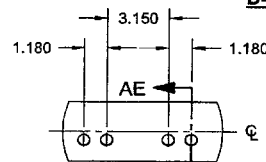
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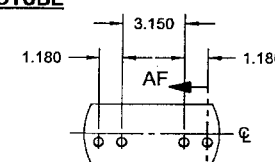
D4168-4 RH SKIDTUBE



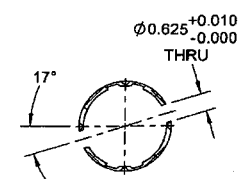
DETAIL AA
SCALE 2X



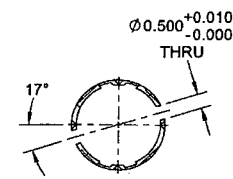
DETAIL AB
SCALE 2X



DETAIL AC
SCALE 2X



SECTION AE-AE
SCALE 3X, 4 PL



SECTION AF-AF
SCALE 3X, 4 PL

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MFG. APPR.		D4168	SHEET 7 OF 11
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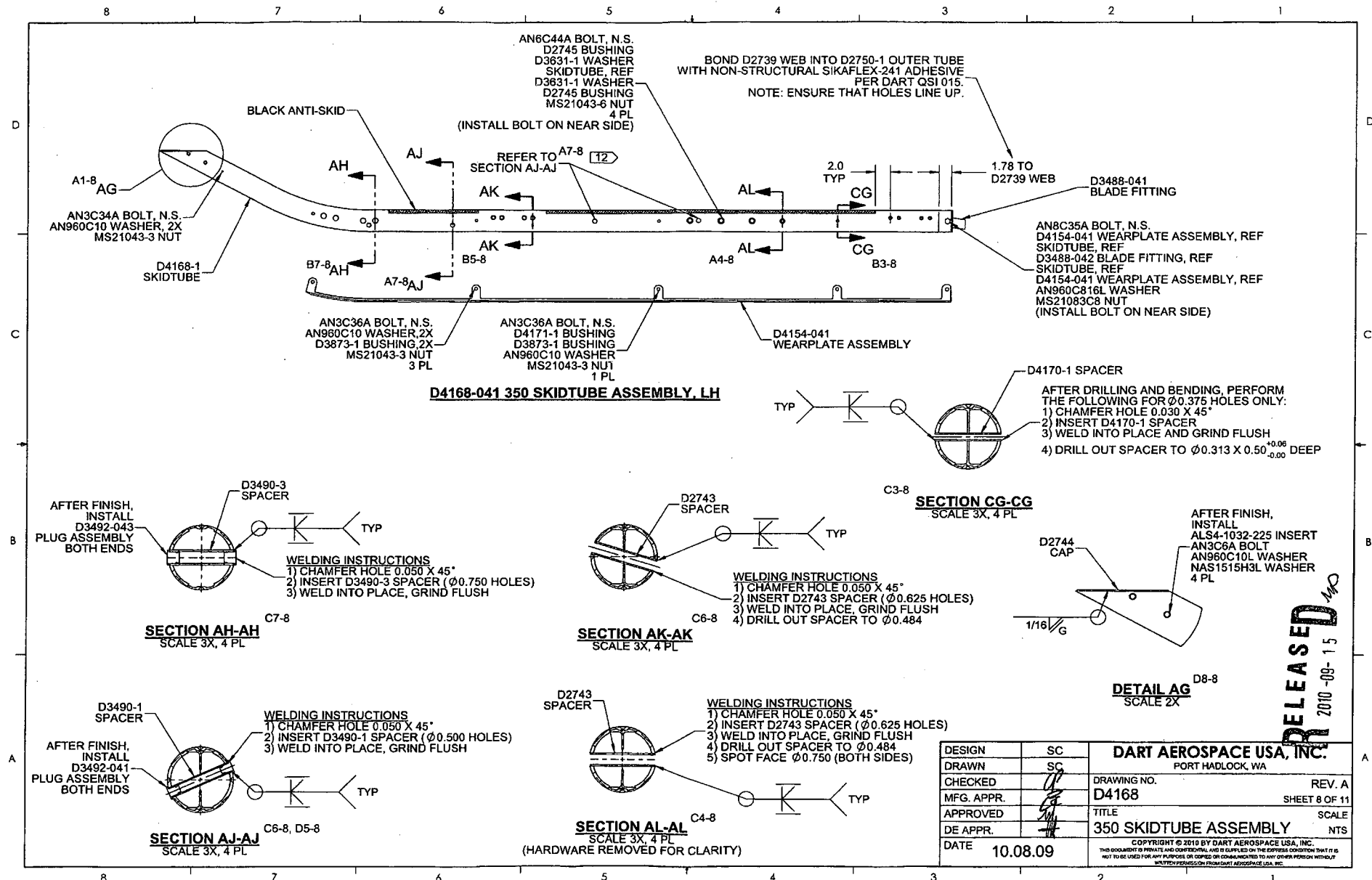
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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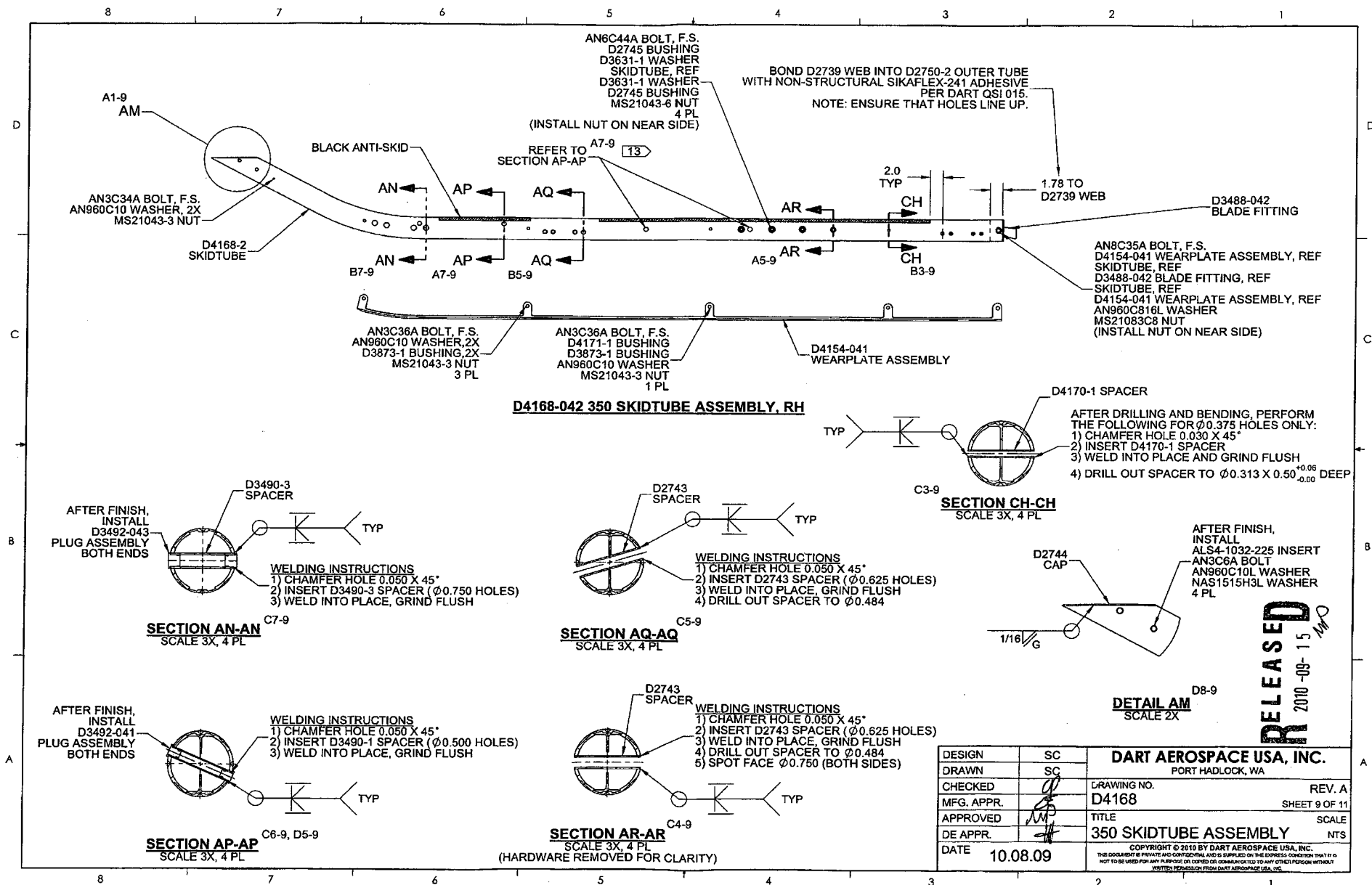
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

8 7 6 5 4 3 2 1

A1-10 AS

BLACK ANTI-SKID

REFER TO SECTION AW-AW

A4-10

AN3C34A BOLT, N.S.
AN960C10 WASHER, 2X
MS21043-3 NUT

D4168-3 SKIDTUBE

AN3C36A BOLT, N.S.
AN960C10 WASHER, 2X
D3873-1 BUSHING, 2X
MS21043-3 NUT
3 PL

WEARPLATE ASSEMBLY

D4154-041

AN3C36A BOLT, N.S.
D4171-1 BUSHING
D3873-1 BUSHING
AN960C10 WASHER
MS21043-3 NUT
1 PL

AN6C44A BOLT, N.S.
D2745 BUSHING
D3631-1 WASHER
SKIDTUBE, REF
D3631-1 WASHER
D2745 BUSHING
MS21043-6 NUT
4 PL
(INSTALL BOLT ON NEAR SIDE)

AT

AU

AV

CJ

2.0 TYP

AW

1.78 TO D2739 WEB

D3488-041 BLADE FITTING

AN8C35A BOLT, N.S.
D4154-041 WEARPLATE ASSEMBLY, REF
SKIDTUBE, REF
D3488-042 BLADE FITTING, REF
SKIDTUBE, REF
D4154-041 WEARPLATE ASSEMBLY, REF
AN960C18L WASHER
MS21083C8 NUT
(INSTALL BOLT ON THIS SIDE)

A7-10

B7-10

A7-10

AU

B4-10

AV

CJ

C3-10

AW

A4-10

D4168-043 350 SKIDTUBE ASSEMBLY, LH

D4170-1 SPACER

TYP

SECTION CJ-CJ
SCALE 3X, 4 PL

D4-10

WELDING INSTRUCTIONS

- 1) CHAMFER HOLE 0.050 X 45°
- 2) INSERT D2743 SPACER (Ø0.625 HOLES)
- 3) WELD INTO PLACE, GRIND FLUSH
- 4) DRILL OUT SPACER TO Ø0.313 X 0.50" DEEP

D2743 SPACER

TYP

SECTION AT-AT
SCALE 3X, 4 PL

D6-10

WELDING INSTRUCTIONS

- 1) CHAMFER HOLE 0.050 X 45°
- 2) INSERT D2743 SPACER (Ø0.625 HOLES)
- 3) WELD INTO PLACE, GRIND FLUSH
- 4) DRILL OUT SPACER TO Ø0.484

D2743 SPACER

TYP

SECTION AV-AV
SCALE 3X, 4 PL
(HARDWARE REMOVED FOR CLARITY)

D4-10

WELDING INSTRUCTIONS

- 1) CHAMFER HOLE 0.050 X 45°
- 2) INSERT D3490-1 SPACER (Ø0.500 HOLES)
- 3) WELD INTO PLACE, GRIND FLUSH

D3490-1 SPACER

TYP

SECTION AU-AU
SCALE 3X, 4 PL

D5-10, D6-10

AFTER FINISH, INSTALL D3492-045 PLUG ASSEMBLY BOTH ENDS

D3490-5 SPACER

WELDING INSTRUCTIONS

- 1) CHAMFER HOLE 0.050 X 45°
- 2) INSERT D3490-5 SPACER (Ø0.313 HOLES)
- 3) WELD INTO PLACE, GRIND FLUSH

D3490-5 SPACER

TYP

D2744 CAP

1/16" G

AFTER FINISH, INSTALL ALS4-1032-225 INSERT AN3C6A BOLT AN960C10L WASHER NAS1515H3L WASHER 4 PL

DETAIL AS
SCALE 2X

D8-10

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DRAWN		SC		PORT HADLOCK, WA	
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MFG. APPR.		SC		D4168 SHEET 10 OF 11	
APPROVED		SC		TITLE SCALE	
DE APPR.		SC		350 SKIDTUBE ASSEMBLY NTS	
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8 7 6 5 4 3 2 1

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NOTE: Date & initial all entries

8 7 6 5 4 3 2 1

BA

AN3C34A BOLT, N.S.
AN960C10 WASHER, 2X
MS21043-3 NUT

D4168-4 SKIDTUBE

REFER TO SECTION BE-BE

BLACK ANTI-SKID

A4-11

AN8C44A BOLT, F.S.
D2745 BUSHING
D3631-1 WASHER
SKIDTUBE, REF
D3631-1 WASHER
D2745 BUSHING
MS21043-6 NUT
4 PL
(INSTALL NUT ON NEAR SIDE)

BB

BC

BD

CK

BE

2.0 TYP

1.78 TO D2739 WEB

D3488-042 BLADE FITTING

AN8C35A BOLT, F.S.
D4154-041 WEARPLATE ASSEMBLY, REF
SKIDTUBE, REF
D3488-042 BLADE FITTING, REF
SKIDTUBE, REF
D4154-041 WEARPLATE ASSEMBLY, REF
AN960C816L WASHER
MS21083C8 NUT
(INSTALL NUT ON NEAR SIDE)

A7-11

B7-11

A4-11

B4-11

B3-11

AN3C36A BOLT, F.S.
AN960C10 WASHER, 2X
D3873-1 BUSHING, 2X
MS21043-3 NUT
3 PL

WEARPLATE ASSEMBLY

D4154-041

AN3C36A BOLT, F.S.
D4171-1 BUSHING
D3873-1 BUSHING
AN960C10 WASHER
MS21043-3 NUT
1 PL

D4168-044 350 SKIDTUBE ASSEMBLY, RH

D2743 SPACER

TYP

WELDING INSTRUCTIONS
1) CHAMFER HOLE 0.050 X 45°
2) INSERT D2743 SPACER (Ø 0.625 HOLES)
3) WELD INTO PLACE, GRIND FLUSH
4) DRILL OUT SPACER TO Ø 0.484

D6-11

SECTION BB-BB
SCALE 3X, 4 PL

D2743 SPACER

TYP

WELDING INSTRUCTIONS
1) CHAMFER HOLE 0.050 X 45°
2) INSERT D2743 SPACER (Ø 0.625 HOLES)
3) WELD INTO PLACE, GRIND FLUSH
4) DRILL OUT SPACER TO Ø 0.484

D4-11

SECTION BD-BD
SCALE 3X, 4 PL
(HARDWARE REMOVED FOR CLARITY)

D4-11

SECTION CK-CK
SCALE 3X, 4 PL

D2744 CAP

1/16" G

AFTER FINISH, INSTALL
ALS4-1032-225 INSERT
AN3C6A BOLT
AN960C10L WASHER
NAS1515H3L WASHER
4 PL

D8-11

DETAIL BA
SCALE 2X

AFTER FINISH, INSTALL
D3492-045
PLUG ASSEMBLY
BOTH ENDS

D3490-5 SPACER

WELDING INSTRUCTIONS
1) CHAMFER HOLE 0.050 X 45°
2) INSERT D3490-5 SPACER (Ø 0.313 HOLES)
3) WELD INTO PLACE, GRIND FLUSH

D5-11, C6-11

SECTION BC-BC
SCALE 3X, 4 PL

AFTER FINISH, INSTALL
D3492-041
PLUG ASSEMBLY
BOTH ENDS

D3490-1 SPACER

WELDING INSTRUCTIONS
1) CHAMFER HOLE 0.050 X 45°
2) INSERT D3490-1 SPACER (Ø 0.500 HOLES)
3) WELD INTO PLACE, GRIND FLUSH

D4-11, D7-11

SECTION BE-BE
SCALE 3X, 4 PL

DESIGN SC
DRAWN SC
CHECKED
MFG. APPR.
APPROVED
DE APPR.
DATE

SC
SC
D
M
D

DART AEROSPACE USA, INC.
PORT HADLOCK, WA

DRAWING NO.
D4168

TITLE
350 SKIDTUBE ASSEMBLY

REV. A
SHEET 11 OF 11
SCALE
NTS

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8 7 6 5 4 3 2 1

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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